



Dart Hawkesbury
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Hawkesbury, ON
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D4634-143
Job Sheet 167077-H



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	2017-12-14/25/1
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	D.M.L 12-17-28
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	D.M.L 17-12-28
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L 17-12-28
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-3 5019746	1	2	0	0
	- D4636-5 5021885	2	43	0	0
	- D4647-1 5021883	1	4	0	0
	- D4664-5 5021882	6	39	0	0
	- D4712-1 5021881	2	4	0	0
	- D4732-21 5021878	1	6	0	0
	- D4732-25 5021877	1	7	0	0
	- D5021-3 5021876	1	2	0	0
	- MPNY-750S-9-C 5021875	3	570	0	0
	- MS20426AD3-4 5021873	4	5,055	0	0
	- MS20426AD4-6 5021872	4	2,797	0	0
	- MS21059L08 5021870	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Descr _____	DISPOSITION Mfg Date: 12/14/17 Job No: 167077 – H	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 15%;">ube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>ring ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coor. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>ring ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	ube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	ring ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	ring ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Fab ☐	Composite ☐	Supplier ☐	
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D4634 – 143 Start up Operation		Effective : _____ Disposition																
		MRB (QSI042) Approval																
		Completed By																
		Lead hand / Supervisor Approval Verification																
		QC / QA Coordinator Approval																

Root Cause <table style="width: 100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No R</td></tr> <tr><td>Design</td><td>☐</td><td>Oper</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offse</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supp</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Train</td></tr> <tr><td>Material</td><td>☐</td><td>Use f</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rush</td></tr> <tr><td>LOA</td><td>☐</td><td>Prod</td></tr> <tr><td>Substation</td><td>☐</td><td>Process improvement</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td></tr> </table>	Environment	☐	No R	Design	☐	Oper	Doc/Data	☐	Offse	Equip/Tooling	☐	Supp	Handling/Pre	☐	Train	Material	☐	Use f	Internal Transport	☐	Poor	Tribal Knowledge	☐	Rush	LOA	☐	Prod	Substation	☐	Process improvement	Past Expiry Date	☐	Manufacturing Process	Misidentified	☐	Past Due	S021943 Middle, Center Ceiling Replacement Panel Assembly	FAULT CATEGORY <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;"> Cure ☐ e/Defect ☐ mplete/Unqualified ☐ omplete/Unclear ☐ </td> <td style="width: 50%;"> ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center </td> </tr> <tr> <td></td> <td> ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>	Cure ☐ e/Defect ☐ mplete/Unqualified ☐ omplete/Unclear ☐	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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PART NO:
Revision:
Operation:
Change No:

Marks/Chatter _____
 Drill Holes _____

OTHER : _____